

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016001**Date Inspected:** 31-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay no.10

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 056200 and 052930 perform SMAW welding on; South shaft, Lift 5, intersection diaphragm plates with Skin E and the weld joint is identified as SSD1-TL5-1 B/F-26A, 25A. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052493 perform SMAW welding on; South shaft, Lift 5, Grillage plate, inside the Lift 5 and the weld joint is identified as SSD1-TL5-1 B/F-31B. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.(Photo attached)

3.This QA inspector, Baskar Govindarajan, observed ZPMC qualified welding personnel identified as 040414 perform SAW welding on; Bike path plates, and the weld joint is identified as BK 004A-032-009. ZPMC CWI Identified as Mr. Liu Yang. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

Bay no. 11

4.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 046769/044541 perform SMAW welding on; East shaft, Lift 5, Grillage plates and the weld joint is identified as ESD1-TL5-2 B/F-33A, 32A. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.

5.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 044551 perform SMAW welding on; East shaft, Lift 5, Grillage plates and the weld joint is identified as ESD1-TL5-2 B/F-32B. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-3213-TC-U5B.

6.This QA inspector, Baskar Govindarajan, observed ZPMC qualified welding personnel identified as 202316 perform SMAW Repair welding on; Spare strut and the weld joint is identified as WD1-STSA4-5-135mtr.-1-9. ZPMC CWI Identified as Mr. Zhao Chen Sun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-Repair.

Paint shop 2

7.This QA inspector, Baskar Govindarajan, observed, porosities, pinhole and Base metal damage in Façade plates SD1-A228 -53 mtr., ED1-A222 and WD1-A145 respectively. Taped all weld repair areas and wrote incident report for tracking the same. Photo of Porosity, pinhole and Base metal repair is attached.

Magnetic Particle Testing:

This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as Lift 2, Manhole cover hinges at Heavy Dock Jetty (Notification no. 06310) The weld designations reviewed are as follows:

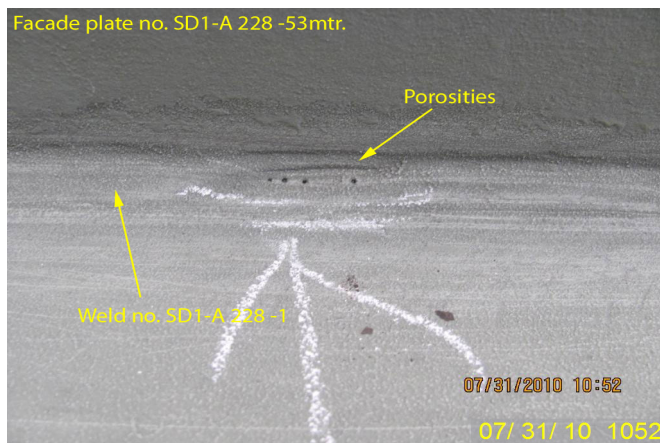
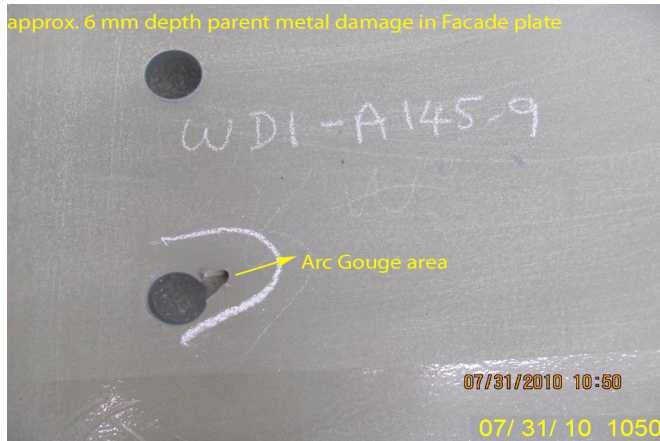
P -21 -E- Jt. nos -1,2 – Lift 2,Manhole cover plate Hinges

P -21 -W- Jt. nos -1,2 – Lift 2,Manhole cover plate Hinges

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Micheal Ng (15921845703), who represents the Office of Structural Materials for your project.

Inspected By:	Baskar,Govindarajan	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
